

86709

July-06-12 11:40:55 AM

N900040100

Setup Start *NS1*

Stop ***NS2***

Start Qty: 6.00 ~~10~~ *6*

Cust Item ID:

Req'd Qty: ~~6.00~~ *6*

Customer:

Run Start *NR1*

Date: 12-07-9

Tooling:

Date:

Stop *NR2*

QC:

Date:

SPC (Y/N):

Date:

[illegible]

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 86709

86709

Page 2

July-06-12 11:40:55 AM

Item ID: D3204-3 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Arm
 Start Date: 7/06/12 Start Qty: 6.00 *6* Cust Item ID:
 Required Date: 8/10/12 Req'd Qty: 6.00 *6* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		1217/26		10	0		
140 *140* Packaging Packaging	Identify as per dwg & Stock Location <u>WA</u> Memo	0.00 0.00				10		12/7/26	
150 *150* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						12/7/30	

MCS 12/07/27

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Picklist Print

July-06-12 11:40:55 AM

Page 1

Work Order ID: 86709

Parent Item: D3204-3

Parent Item Name: Arm

Start Date: 7/06/12

Required Date: 8/10/12

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: C05.08.11Added Step 25 KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.500X02.000 6061-T6 Bar .500 x 2.00		Purchased	No			100	f	23.0000	0.5538	3.4976844			

Location

Loc Qty

Loc Code

MAT002

23

120708

23

5.83 on 12/07/12

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DART AEROSPACE LTD		Work Order:	84709
Description: Arm		Part Number:	D3204-3
Inspection Dwg: D3204	Rev: A1	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.00	+/-0.030	6.000	—		Visual	
5.25	+/-0.030	5.250	—		"	
0.776	+/-0.010	.776	—		"	
Ø0.760	+0.005/-0.000	Ø.760	—		"	
0.080	+/-0.010	.082	—		"	
R0.50	+/-0.010	R.500	—		"	
2.373	+/-0.010	2.373	—		"	
0.750	+/-0.010	.757	—		"	
R0.380	+/-0.010	R.380	—		"	
Ø0.375	+0.001/-0.000	Ø.375	—		"	
0.300	+/-0.010	.297	—		"	

Measured by: DAS 14 smf	Audited by: 1 DAS 14 smf	Prototype Approval:	N/A
Date: 12/07/26	Date: 12/7/26	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.02.17	New Issue	KJ/JLM	
B	06.03.21	Dwg Rev update	KJ/JLM	

Dart Aerospace Ltd

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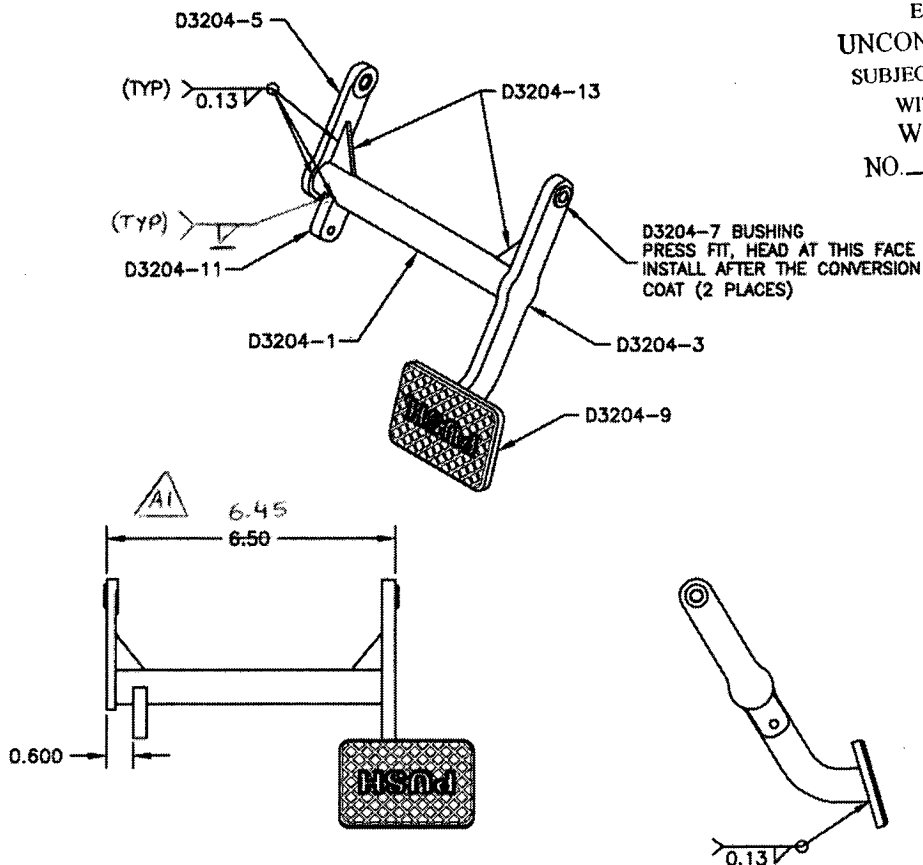


DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3204	REV. A SHEET 1 OF 3
DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS
A	04.01.27	NEW ISSUE	
A1	05.07.15	6.45 WAS 6.50	

RELEASED
04.04.30

SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 86709

R12-07-9



D3204-041 RELEASE PEDAL ASSEMBLY

NOTES

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 OR -T62 (QQ-A-200/8) 0.750 OD x 0.125 WALL (M6061T6T0.75W.125)
- 3) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) BAR (M6061T6B)
- 4) MATERIAL: AISI 303 SS (M303R)
- 5) MATERIAL: 6061 (QQ-A-250/11) SHEET 0.125 THICK (M6061T6S.125)
- 6) ENGRAVE "PUSH" USING 0.5" HIGH LETTERS TO DEPTH OF 0.010 TO 0.020
ENGRAVE DART P/N USING 0.125 LETTERS TO MAX DEPTH OF 0.010
- 7) WELD ASSEMBLY PER QSI 004
- 8) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 9) POWDER COAT ASSEMBLY GREY SANDTEX (REF. 4.3.5.6) PER QSI 005 4.3
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 11) ALL DIMENSIONS ARE INCHES

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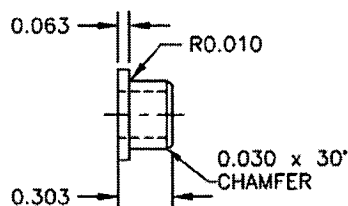


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DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS

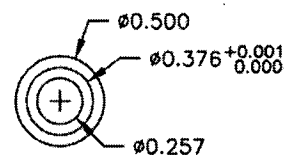
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04.04.05 [Signature]



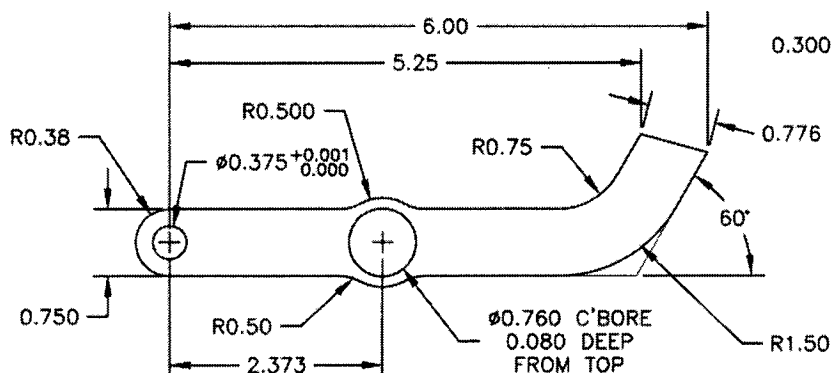
2 D3204-1 TUBE
SCALE 1:2



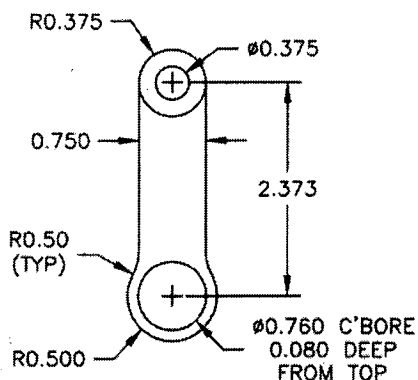
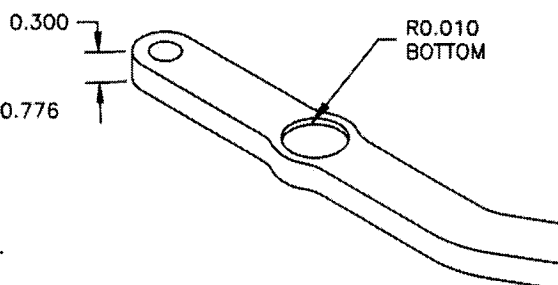
4 D3204-7 BUSHING
SCALE 1:1



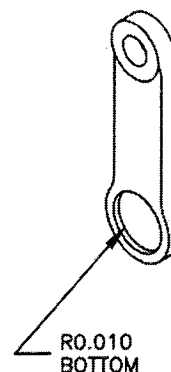
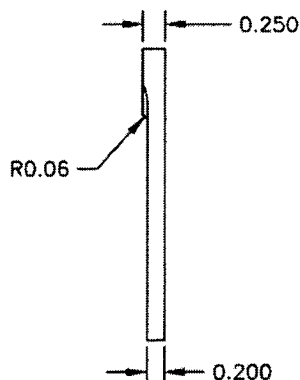
86709



3 D3204-3 ARM
SCALE 1:2



3 D3204-5 ARM
SCALE 1:2



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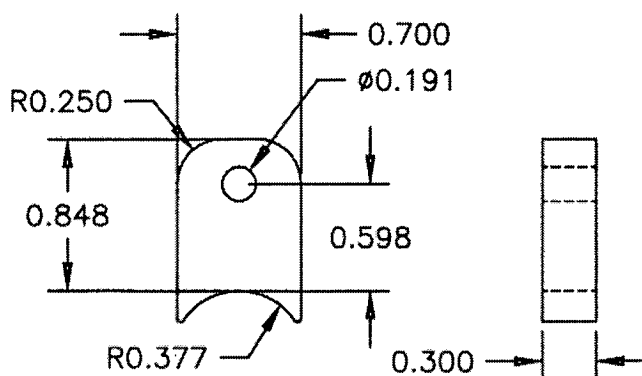
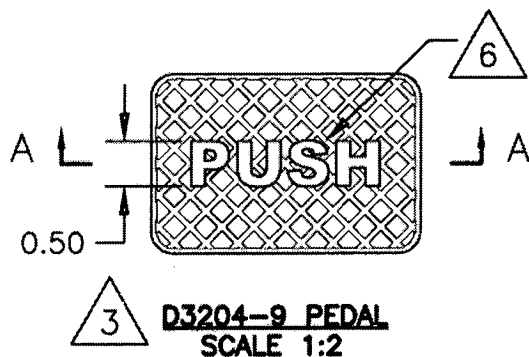
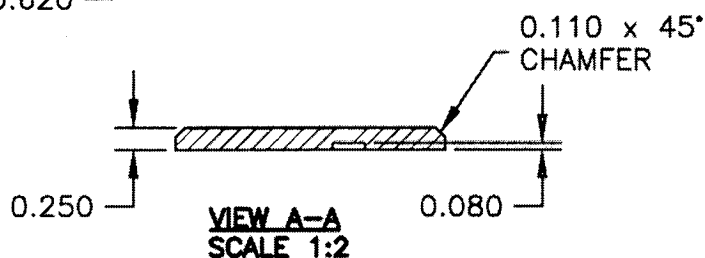
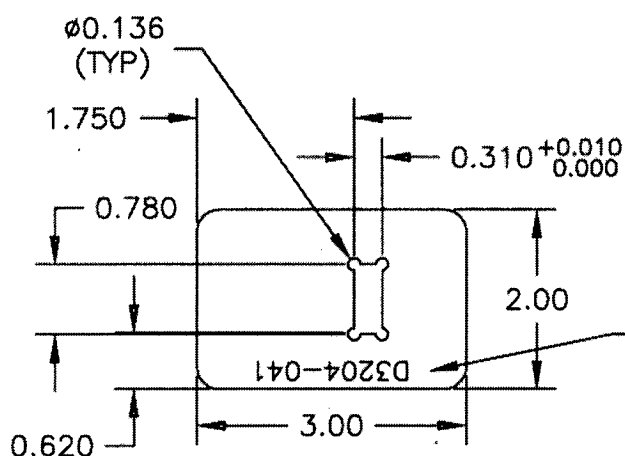
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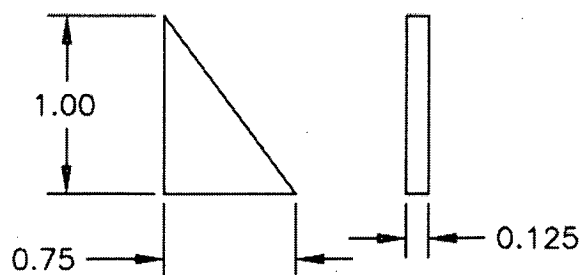
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3204	REV. A SHEET 3 OF 3
DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS

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D3204-11 PLATE
SCALE 1:1

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D3204-13 GUSSET
SCALE 1:1

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